

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 01.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029965**Date Inspected:** 27-Aug-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Flour Enterprises, a JV**Location:** Job Site

<b>CWI Name:</b>	Jesus Cayabyab & Bernie Docena			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>

**Bridge No:** 34-0006**Component:** See Below**Summary of Items Observed:**

Quality Assurance Inspector (QAI) Edward Leach was at the American Bridge/Flour (ABF) job site at Yerba Buena Island between the times noted above in order to monitor Smith Emery Quality Control (QC) functions and the in process work being performed by ABF personnel. The following items were observed:

ESW Repair Excavation

RWR201308-004

ESW S-043, Location "T" Face B

The QAI observed ABF welding personnel Mike Jimenez performing excavations in two locations of ESW "T" Face B @ Y=4690mm & Y=4100mm to verify indications observed during Ultrasonic Testing pulse/echo & pitch/catch. Mr. Jimenez was performing the excavations using an air carbon arc gouging and a grinder. Mr. Jimenez was instructed by QC Inspector Jesus Cayabyab to notify him when indications were visible to allow time for QC/QA to inspect the excavation and perform informational Magnetic Particle Testing (MT) examination. The QAI was informed by QC Inspector welder visually identified slag in both excavations. QC Inspector instructed welder to clear indications and grind the excavation with a dye grinder.

The following dimensional measurements were recorded for both excavations by QC & QAI:

Excavation #1 Y=4690mm~4990mm, Depth=70mm, Width=65mm. Excavation #2 Y=4100mm-4410mm, Length=310mm, Depth=70mm, Width=68mm. The QAI and the QC Inspector performed MT inspection of the ground excavations to verify removal of indications. No relevant indications were noted.

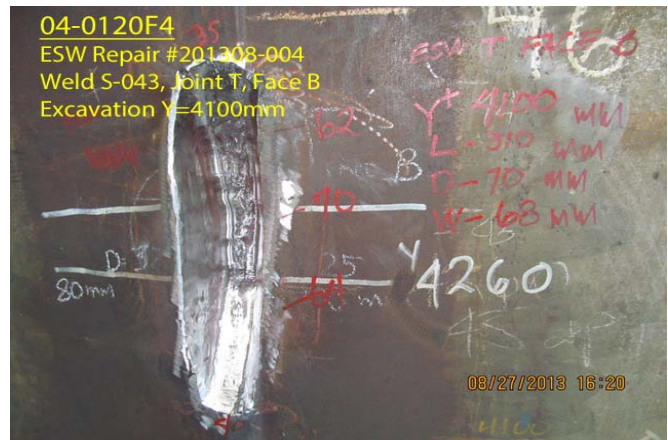
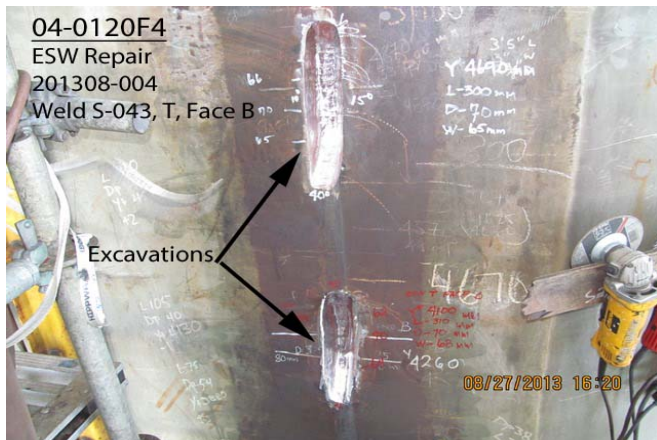
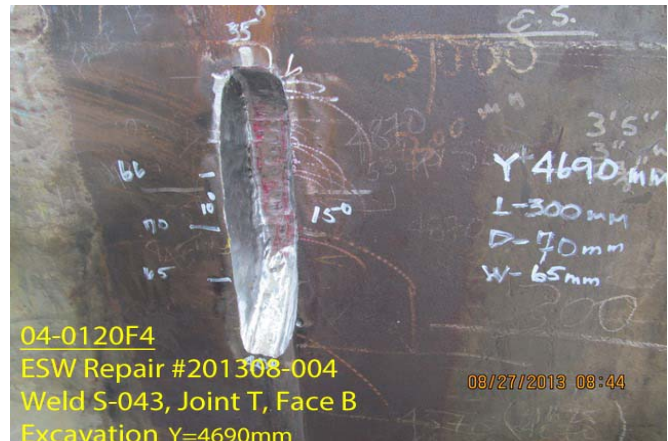
Tower Skirt Ring Beam East Shaft

The QAI observed ABF welding personnel Richard Chounard perform in process fit up for tower skirt ring beam

# WELDING INSPECTION REPORT

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on the corner of the east tower shaft for weld joints 164, 165, 166. The QAI and QC Inspector Bernie Docena inspected the fit up to verify compliance with the contract specifications. Mr. Bernie Docena accepted and signed off fit up on this date.



## Summary of Conversations:

General conversations with ABF/JV QC NDT personnel relevant to work and testing performed during this shift.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

**Inspected By:** Leach,Ed

Quality Assurance Inspector

**Reviewed By:** Reyes,Danny

QA Reviewer